

Work Order ID 130946

March-26-15 1:31:01 PM

646.3813
B130946
REV. N/C

130946

Page 1

Item ID: 646.3813

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Strut Bracket

Start Date: 3/26/15

Start Qty: 3.00

3

Cust Item ID:

Required Date: 3/26/15

Req'd Qty: 3.00

3

Customer:

Reference:

Approvals:

Process Plan: MLS

Date: 15-03-30

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

646.3800

N/C

110

0.00

110

HAAS CNC VERTICAL MACHINING #1

Mill Conv

Memo

0.00

Conventional Milling Machine

1-Machine per DWG
DWG REV: N/C

3

0

J.C.-L.

15/03/30

2- deburr and break all sharp edges

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

3

0

J.C.-L.

15/03/30

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Training									
Transport									
Unapproved									

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Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 130946

130946

Page 3

March-26-15 1:31:01 PM

Item ID: 646.3813 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Strut Bracket
 Start Date: 3/26/15 Start Qty: 3.00 *3* Cust Item ID:
 Required Date: 3/26/15 Req'd Qty: 3.00 *3* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
155	QC5- Inspect part completeness to step on W/O	0.00							DAS 38 9-89
155						(3)			MAY 01 2015
QC	Memo	0.00							
Quality Control									
180	Identify as per dwg & Stock Location: <u>CCKAS</u>	0.00							
180						3	(40)		MAY 04 2015
Packaging	Memo	0.00							
Packaging	***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***								
190	QC21- Final Inspection - Work Order Release	0.00							
190						MLJ			MAY 05 2015
QC	Memo	0.00							
Quality Control									

MLJ MAY 04 2015

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Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

March-26-15 1:31:00 PM

Page 1

Work Order ID: 130946

130946

Parent Item: 646.3813

646.3813

Parent Item Name: Strut Bracket

Start Date: 3/26/15

Required Date: 3/26/15

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP REV:A NEW ISSUE 12-10-22 JLM VERIFIED:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M7075T6A0.75X0.75X 0.060X0.060		Purchased		No			f	0.0000		1			

***M7075T6A0 75X0 75X0 060X0**

7075T6 ANGLE .75" X .75" X .060" X .062"W

J.C. -L

M123947 ~~4~~ 0.797' 15/03/30

DQA: _____ Date: _____



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Large Fab ☐	Composite ☐	Supplier ☐																

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Equip/Tooling									
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		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
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APICAL INDUSTRIES, INC.	ENGINEERING CHANGE NOTICE NO. 03697				SHEET 1 OF 1	
	DWG NO. 646.3800		REV: N/C	PREPARED BY B. PETERS	DATE: 11/14/12	EFFECT ON DWG ☐ INC. ☒ UNINC.
	DWG TITLE: BRACKETS					
	APPROVED BY:	ENGR <i>[Signature]</i>	MFG <i>David Barber</i>	QC <i>[Signature]</i>	EFF: NEXT ORDER	
TRANSACTION CODES (TC) A-ADD C-CREATE R-REVISE D-DELETE	REASON: ADDED ALTERNATE MATERIAL.				ECR: D-12-006	

IS

1 PRIMARY MATERIAL: 7075-T651 ALUMINUM PER AMS-QQ-A-250/12.
ALTERNATE MATERIAL: 7075-T6511 ALUMINUM PER AMS-QQ-A-200/11.

SHOW COPY
DATE: 11/14/12
BY: B. PETERS
UNCLASSIFIED
DATE: 11/14/12
BY: B. PETERS

130946 MJS
1503-30

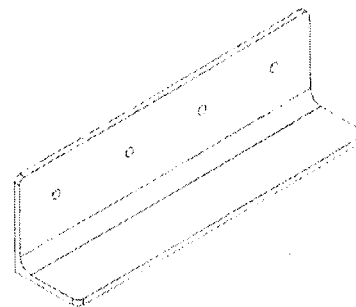
SHEET 1, ZONE A2 IS:

F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL	SPECIFICATION
DOCUMENTS EFFECTED:					CHANGE CATEGORY	DER REVIEW REQUIRED
☐ RFMS ☐ MDL ☐ INSTALL INSTRU ☐ ICA ☐ BOM					☐ MAJOR ☒ MINOR	☐ YES ☒ NO

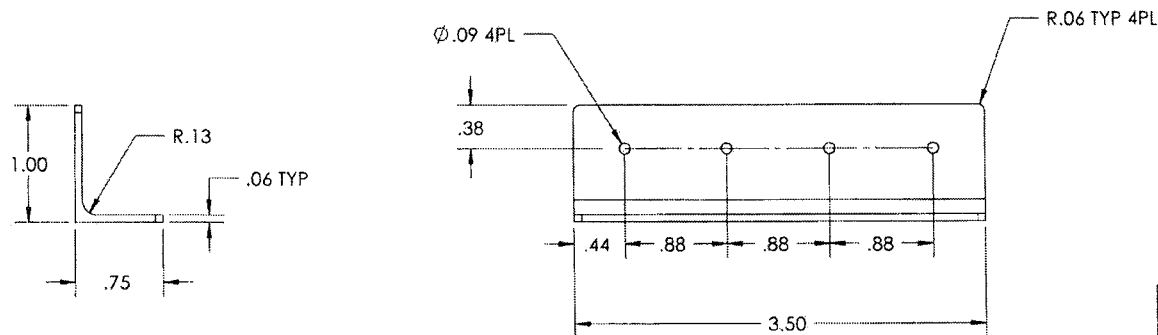
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NOTES:

- 1 MATERIAL: ALUMINUM 7075-T651 AMS-QQ-A-250/12
- 2 FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK;
CARDINAL 4840-50 PRETREATMENT PRIMER
PRIME IAW MIL-P-23377J TYPE I CLASS N
3. DEBURR AND BREAK ALL SHARP EDGES
4. IDENTIFY IAW MPP-120



646.3810



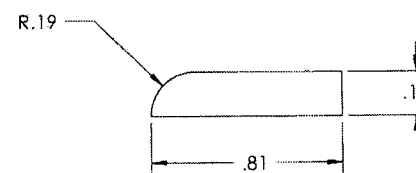
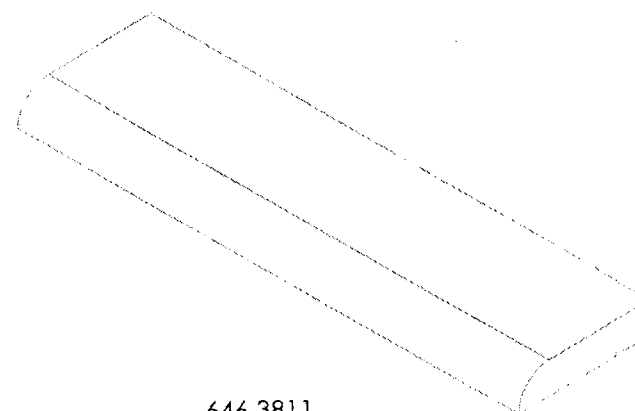
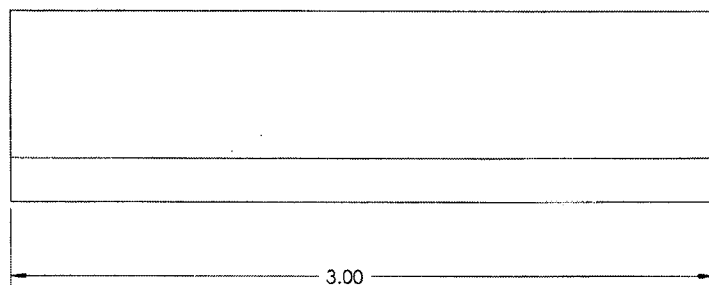
UNINCORPORATED ECU (3)

03/09/7

QTY	QTY FIND #	PART #	DESCRIPTION	MATL	SPEC.
		646.3814	WIPER BRACKET	△	△
		646.3813	STRUT BRACKET	△	△
		646.3812	GUSSET BRACKET	△	△
		646.3811	RADIUS BLOCK	△	△
		646.3810	BRACKET	△	△
PARTS LIST			APICAL INDUSTRIES		
NEXT ASSY (S):			2608 TEMPLE HEIGHTS DR.		
646.4000			OCEANSIDE, CA. 92056-3512 (760)724-5300		
			BRACKETS		
			646.3800		
			SCALE NONE		
			SHEET 1 OF 5		

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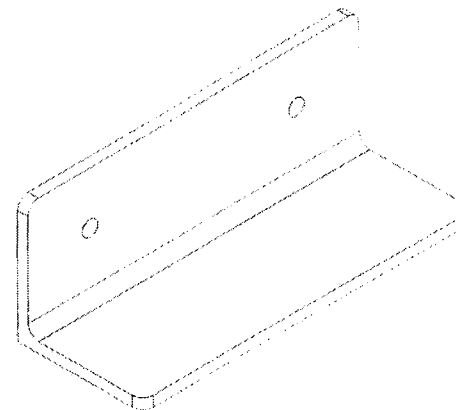
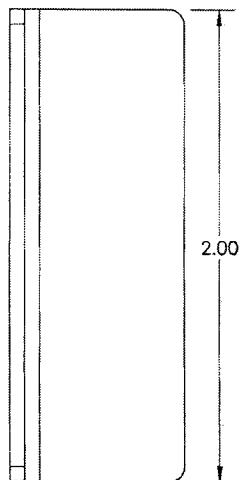
REVISIONS			
REV	DESCRIPTION	DATE	APPROVED



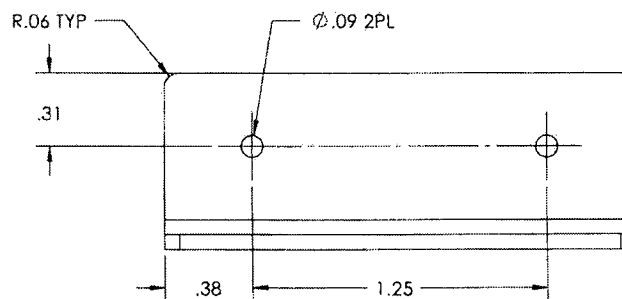
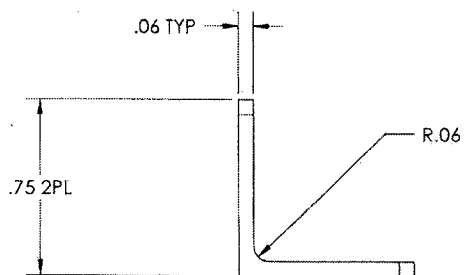
NEXT ASSY (S)	ORIGINAL DATE 05-19-06	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300 BRACKETS	
	AND DATES DRAWN BY JGARDNER		
	CHECKED BY		
	DRAWING APPROVAL		
CONTRACT NO.			
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES CONTRACT DATE 3 PLACE DECIMALS ± .005 ANGLES ± .1°			
SHEET CODE B		DWG. NO. 07M26	REV. N/C
SCALE NONE		646.3800	
		SHEET 2 OF 2	

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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED



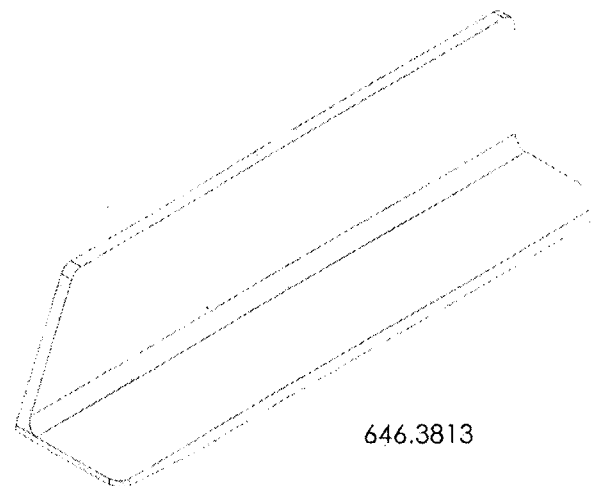
646.3812



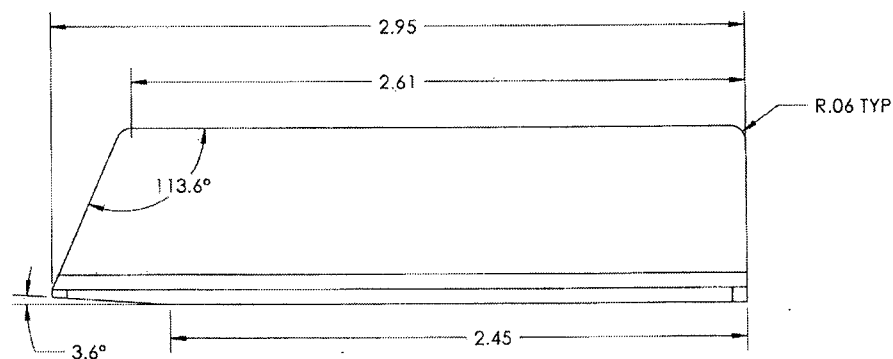
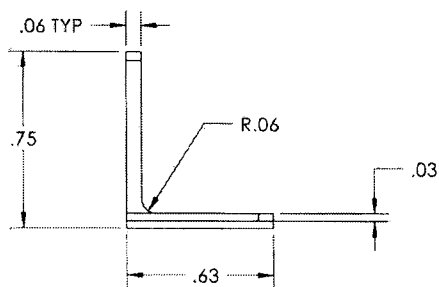
NEXT ASSY (S)	ORIGINAL DATE 06-19-06	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
	MODIFIED BY		
	DESIGNED BY	BRACKETS	
	DRAWING APPROVAL		
	CONTRACT NO.	646.3800	
	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 3 PLACE DECIMALS ±.010 ANGLES ±.5		
		SCALE NONE	SHEET 3 OF 3

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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED



646.3813

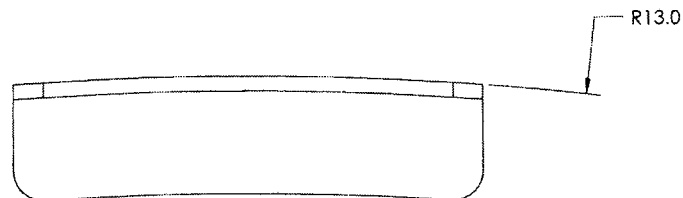


NEXT ASSY (S)		ORIGINAL DATE: 08-19-08	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300	
		DRAWN BY: /GARDNER		
		CHECKED: /		
		DATE: /		
		CONFIRMED: /	BRACKETS SEE TOLERANCE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS: ±.010 3 PLACE DECIMALS: ±.005 ANGLES: ±.5°	
			SCALE: NONE	SHEET: 4 OF 5

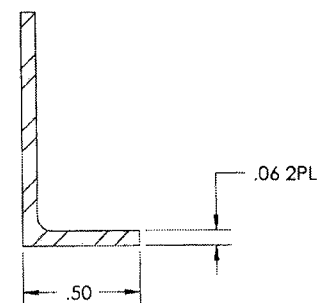
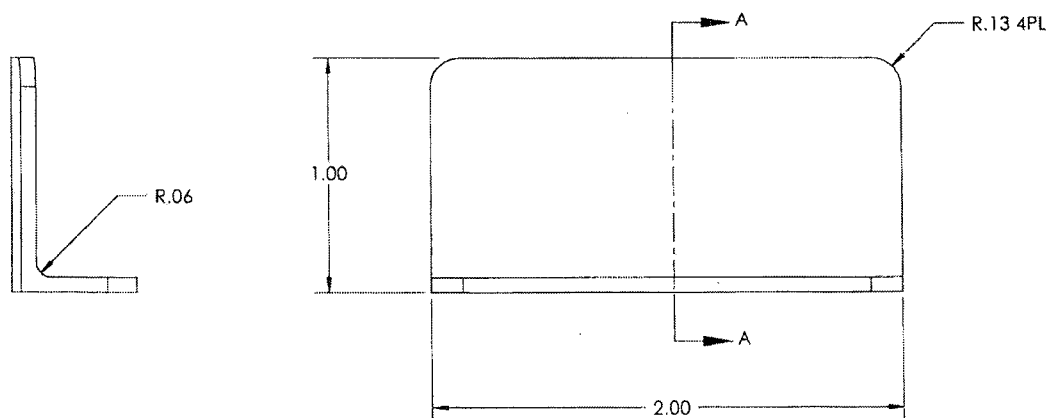
2608 TEMPLE HEIGHTS DR.
 OCEANSIDE, CA. 92056-3512 (760) 724-5300
BRACKETS
 646.3800
 N/C

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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED



646.3814



SECTION A-A

NEXT ASSY (S)	ORIGINAL DATE	08-15-08	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA, 92056-3512 (760)724-5300	
	DESIGNED BY	ENGINEER		
	DRAWN BY	J. GARDNER		
	CHECKED BY	APPROVED		
CONTRACT NO.			BRACKETS 646.3800	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: FRACTIONS DECIMALS ANGLES 1/16 0.0001 1.000				
SCALE			NONE	SHEET 5 OF 5



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO27987**

Purchase Order Date 4/1/2015

PO Print Date 4/16/2015

Page Number 2 of 8

Order From :

VC-ATG001

A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE ROAD
ROCKLAND, ON K4K 1T2
CANADA

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 613-446-4544

Ship To Contact

Ship To Phone

Ship Via: VENDOR'S TRUCK

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax # 10127-2607

Terms

Net 30

Currency

CAD

FOB

FCA - (Free Carrier)

3	131050	646.3715 STRUT DOUBLER REV. A	4/24/2015	8.00	\$6.25	\$50.00
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Yes

4/24/2015

FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2 / PRIME AS PER IAW MIL-P-23377J TYPE 1 CLASS N

Line Total: \$50.00

4	130858	646.3812 GUSSET BRACKETREV. N/C	4/24/2015	3.00	\$6.10	\$18.30
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Yes

4/24/2015

FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2 / PRIME AS PER IAW MIL-P-23377J TYPE 1 CLASS N

Line Total: \$18.30

5	130946	646.3913 STRUT BRACKET REV. N/C	4/24/2015	3.00	\$6.10	\$18.30
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Yes

4/24/2015

FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2 / PRIME AS PER IAW MIL-P-23377J TYPE 1 CLASS N

Line Total: \$18.30

Note:

4/16/2015

895-04-24



A.T.G. Industries Inc.
731, rue Industrielle Rd.
PLATING DEPARTMENT
Rockland, On K4K 1T2
Canada
Ph: (613) 446-4544
Fax: (613) 446-4556

Pack List

Number: 63666

Date: 24-Apr-15

To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ship To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Terms		Ship Via	
Quantity	Description		
10 ea	Part: D5092-041 DOUBLER ASSEMBLY BLACK ANODIZE MIL-A-8625 TYPE II CLASS 2 Job: 20150292	Rev: B	PO: PO27987 Line:
4 ea	Part: 646.3012 LOWER GUIDE HARD ANODIZE AS PER MIL-A-8625 TY III, CLASS 2 PRIME AS PER MIL-P-23377J TYPE I CLASS N PRIMER IS SUPPLY BY THE CUSTOMER Job: 20150293	Rev: N/C	PO: PO27987 Line:
8 ea	Part: 646.3715 STRUT DOUBLER HARD ANODIZE AS PER MIL-A-8625 TY III, CLASS 2 PRIME AS PER MIL-P-23377J TYPE I CLASS N PRIMER IS SUPPLY BY THE CUSTOMER Job: 20150294	Rev: A	PO: PO27987 Line:
3 ea	Part: 646.3812 GUSSET BRACKET HARD ANODIZE AS PER MIL-A-8625 TY III, CLASS 2 PRIME AS PER MIL-P-23377J TYPE I CLASS N PRIMER IS SUPPLY BY THE CUSTOMER Job: 20150295	Rev:	PO: PO27987 Line:
3 ea	Part: 646.3813 STRUT BRACKET HARD ANODIZE AS PER MIL-A-8625 TY III, CLASS 2 PRIME AS PER MIL-P-23377J TYPE I CLASS N PRIMER IS SUPPLY BY THE CUSTOMER	Rev: N/C	

SP 15-04-24.



A.T.G. Industries Inc.
 731, rue Industrielle Rd.
 PLATING DEPARTMENT
 Rockland, On K4K 1T2
 Canada
 Ph: (613) 446-4544
 Fax: (613) 446-4556

Pack List

Number: 63666

Date: 24-Apr-15

To

DART AEROSPACE LTD
 1270 ABERDEEN ST.
 HAWKESBURY, ON K6A 1K7
 Canada

Ship To

DART AEROSPACE LTD
 1270 ABERDEEN ST.
 HAWKESBURY, ON K6A 1K7
 Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Terms		Ship Via	
Quantity	Description		
	Job: 20150309	PO: PO27987	Line:
2 ea	Part: D4703-043 LOCK PIN HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2 Job: 20150310	Rev: A	Line:
Certificate of Conformance A.T.G. Industries certifies that all items in this shipment are in conformance with all requirements, specifications and drawings referenced in the purchase order. ISO 9001 : 2008 REGISTERED ATG SALES-2010 TERMS APPLY DATE : <u>24/4/15</u> CERTIFIED SIGNATURE : <u></u> RECEIVER SIGNATURE : _____			